

PRODUCT BULLETIN
GYPSUM PRODUCTS

RAYMOND MILL
GROUND RAW GYPSUM

BULLETIN NO: R-3

DATE: 1/15/69

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CANCELS: R-3

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This bulletin covers operating specifications, product specifications, and required tests for Raymond Mill ground raw gypsum. Separate product specifications are listed for each type Raymond Mill product according to use and producing plant.

PRODUCING PLANTS:

Long Beach, Antioch, Seattle, Jacksonville, and Delanco

| USES: | Type 1 | Type 2 | Type 3 | Type 4 |
|-------|-----------------------------|--------------------------|--|-----------------------------------|
| | Ground Raw Gypsum | Ground Raw Gypsum | Ground Raw Gypsum | Ground Raw Gypsum |
| | Board Stucco (S-1) | Hardwall Stucco (S-3) | Gauging and Casting Stucco (S-4) | Aridized Plaster Stucco (S-5A) |
| | Board Accelerator (BG-1) | Agricultural Gypsum | | |

OPERATING SPECIFICATIONS:

1. Produced from pebble gypsum (Bulletin R-2) by grinding in high side or low side Raymond Mills.
2. Feed rate to the mills shall be maintained uniform. At Jacksonville and Delanco, dry rock fed to the pebble gypsum bin as required to enable proper Raymond Mill feed rate control.
3. The discharge air temperature above the Raymond Mill shall not exceed 250° F in order to prevent premature calcination of ground gypsum.
4. Adjustments in Raymond Mill operations shall be made as required to maintain product specification conformance. The 100 mesh screen test is used as the control basis
5. Raymond Mill operating instructions shall be posted beside each Raymond Mill control panel to be used by the operators to maintain uniform product quality. In addition to start-up and shut-down procedures, instructions should include required whizzer speed, differential mill pressure range, mill drive motor amperage, damper settings and product fineness specifications for each product.
6. All pertinent operating data shall be recorded at the time of product sampling along with product fineness test results.

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PRODUCT SPECIFICATIONS:

TYPE 1 GROUND RAW GYPSUM

| | <u>Long Beach</u> | <u>Antioch</u> | <u>Seattle</u> | <u>Jacksonville & Delanco</u> |
|-------------------------|-------------------|----------------|----------------|-----------------------------------|
| <u>Fineness</u> | | | | |
| Retained on 30 mesh (%) | 0.5 max. | 0.5 max. | 0.5 max. | 0.5 max. |
| Passing 100 mesh (%) | 78-84 | 88-96 | 94-99 | 91-99 |

NOTE: At Long Beach, Jacksonville, and Delanco Type 1 Ground Raw Gypsum used for aridized hardwall plaster shall be produced from coarse rock screened as for Type 2 Ground Raw Gypsum.

TYPE 2 GROUND RAW GYPSUM

| | <u>Long Beach</u> | <u>Antioch</u> | <u>Seattle</u> | <u>Jacksonville & Delanco</u> |
|-------------------------|-------------------|----------------|----------------|-----------------------------------|
| <u>Fineness</u> | | | | |
| Retained on 30 mesh (%) | 0.5 max. | 0.5 max. | 0.5 max. | 0.5 max. |
| Passing 100 mesh (%) | 78-84 | 91-96 | 96-100 | 96-100 |

NOTE:

At Long Beach, Type 2 Ground Raw Gypsum shall be produced from coarse rock screened over a 0.268 x 0.75 inch vibrating screen to produce maximum purity rock for good compressive strength and white color on plaster products.

TYPE 3 GROUND RAW GYPSUM

All Plants

| | |
|-------------------------|-----------|
| <u>Fineness</u> | |
| Retained on 30 mesh (%) | 15.0 max. |
| Passing 100 mesh (%) | 58-68 |

NOTE:

1. At Long Beach, Type 3 Ground Raw Gypsum shall be produced from coarse rock screened over a 0.268 x 0.75 inch vibrating screen to produce maximum purity rock for good compressive strength and white color on plaster products.
2. At Antioch, Type 3 Ground Raw Gypsum shall be produced from coarse rock screened over a 0.375 x 0.375 inch vibrating screen to produce maximum purity rock for good compressive strength and white color on plaster products.

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| | | TYPE 4 GROUND RAW GYPSUM | | | |
|-------------------------|--|--------------------------|----------|----------|------------------------|
| | | Long Beach | Antioch | Seattle | Jacksonville & Delanco |
| Fineness | | | | | |
| Retained on 30 mesh (%) | | 0.5 max. | 0.5 max. | 0.5 max. | 0.5 max. |
| Passing 100 mesh (%) | | 78-84 | 85-90 | 96-100 | 96-100 |

NOTE: At Long Beach Type 4 Ground Raw Gypsum shall be produced from coarse rock screened as for Type 2 Ground Raw Gypsum.

REQUIRED TESTS:

1. Raymond Mill Control - By Operators

- a. When the product is within specifications, a minimum of two random samples per shift shall be taken from each operating mill. One sample shall be taken at the beginning of the shift; the other near the middle of the shift.
- b. Test frequency shall be increased as required to maintain product specification conformance. Proper mill adjustments defined by the mill supervisor shall be made as required based upon fineness test results.
- c. All test results and mill adjustments made shall be recorded.

2. Raymond Mill Tests - By Laboratory

- a. A minimum of one sample per day shall be taken from the kettle feed supplied by each mill and shall be tested for free water and purity. Test each sample for fineness according to the specifications listed on Pages 2 and 3 of this Bulletin.
- b. If hot pit hardwall stucco normal consistency is low or variable, chloride tests shall be made as required.
- c. More frequent testing for free water and purity should be scheduled when new shipment of rock is received and when stockpile is low.

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